



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2662-2

Job Sheet 186287



Part No: D2662-2

Job Qty: 5 pcs

Part Name: Saddle, LH Fwd, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 11/19/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV E IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP REV:D REDESIGN
PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	5 pcs	11/19/18		0.00	6.20	HAAS - 1		SB2 18/11/15
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	5 pcs	11/19/18		0.00	1.27	Conventional Mill - 1 - B4B		SBL 18/11/16
							Conventional Mill - 2 - B4B		
120	QC 2	5 pcs	11/19/18		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 16		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		

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Container No: S128048



Part: D2662-2

Job No: 186287

Serial No/Batch: S128048

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
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Date: 11/15/16

				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	SBL 18/11/16
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 8 - 12	
				QC 8 - 14	
130 QC 8	5 pcs	11/19/18	0.00 0.00	QC 8 - 16	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	mmL 18/11/18
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
140 Handfinish - 1-1 Chemical-B4B	5 pcs	11/19/18	0.00 0.14	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 18/11/19
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 -	
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11/13/2018

[Dart Hawkesbury] Job Sheet - White, Jesse

				B4B	
150	Powdercoat - 1 White GI(A)- B4B	5 pcs	11/19/18	0.00 0.15	Powdercoat - 1 - B4B Powdercoat - 2 - B4B Powdercoat - 3 - B4B Powdercoat - 4 - B4B
160	QC 3	5 pcs	11/19/18	0.00 0.00	QC 3 - 10 QC 3 - 13 QC 3 - 15 QC 3 - 16 QC 3 - 17 QC 3 - 18 QC 3 - 2 QC 3 - 26 QC 3 - 28 QC 3 - 3 QC 3 - 30 QC 3 - 34 QC 3 - 36 QC 3 - 38 QC 3 - 41 QC 3 - 51 QC 3 - 58 QC 3 - 59 QC 3 - 6 QC 3 - 68 QC 3 - 9
170	Packaging 3-1 - Stock - B4B	5 pcs	11/19/18	0.00 0.00	Packaging 3 - 1 - B4B Packaging 3 - 2 - B4B Packaging 3 - 3 - B4B Packaging 3 - 4 - B4B Packaging 3 - 5 - B4B Packaging 3 - 6 - B4B Packaging 3 - 7 - B4B Packaging 3 - 8 - B4B Packaging 3 - 9 - B4B Packaging 3 - 10 - B4B Packaging 3 - 11 - B4B Packaging 3 - 12 - B4B Packaging 3 - 13 - B4B Packaging 3 - 14 - B4B Packaging 3 - 15 - B4B Packaging 3 - 16 - B4B Packaging 3 - 17 - B4B
180	QC 21 - SA	5 pcs	11/19/18	0.00 0.00	QC 21 - SA - 16 QC 21 - SA - 21
Part Op 100 - (HAAS CNC Vertical Machine), Program part number and batch number. Inspect part number and batch number are Descriptions: programmed MACHINE AS PER FOLIO FB069 & DWG DWG REV: <u>AA</u> FOLIO REV: <u>E</u> 110 - (Manufacture as per dwg), Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: <u>10:30</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>11:00</u> 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: 180 - QC21- Final Inspection - Work Order Release					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	5 Ea (1 ea)	100-HAAS 4 Axis	5038650

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2AC
38
93-8

2AC
38
93-8

2AC
38
93-8

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-001	5	64	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD				Work Order: 186 287	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-2	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.257	.257	.257	.257	.257
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.123	.122	.125	.125	.123
G	0.210	0.230		.223	.222	.225	.225	.225
H	0.615	0.685		.685	.685	.685	.685	.685
I	2.470	2.510		2.494	2.494	2.494	2.496	2.494
J	1.313	1.343		1.327	1.326	1.327	1.328	1.327
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.135	1.135	1.135	1.135	1.135
N	0.100	0.180		.135	.130	.132	.132	.135
O	0.100	0.140		.127	.127	.128	.128	.128
P	0.240	0.260		.250	.250	.250	.250	.250
Q	0.677	0.697		.687	.687	.685	.685	.686
R	0.540	0.560		.550	.550	.551	.500	.500
S	0.912	0.932		.921	.924	.921	.922	.921
T	0.787	0.807		.795	.794	.795	.795	.795
U	5.990	6.010		5.998	6.000	5.995	5.998	5.999
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.500	.500	.500	.499	.499
X	0.312	0.319		.318	.313	.313	.313	.313
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.130	.134	.134	.133	.133
AE	0.235	0.240		.239	.239	.239	.239	.239
AF	0.510	0.515		.510	.500	.510	.510	.510
AG	0.100	0.120		.109	.110	.110	.110	.110
AH	1.565	1.585		1.575	1.575	1.575	1.575	1.575

DAS Accept/Reject

Measured by: 57 18/11/16	Date: 18/11/16
Audited by: mark	Date: 18/11/18
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	11

